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RB23003267-9
Job Sheet 197220



Part No: RB23003267-9

Job Qty: 2 pcs *4 mll*

Part Name: #22 Drill Bit & Block Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Due Date: 8/5/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB23003267 Rev.4 IPP Rev. A 19.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Small Fab - 1	2 pcs	8/5/19	8/5/19	0.08	0.25	Small Fab - 1		
							Small Fab - 2		<i>M/L</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	8/5/19	8/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Small Fab - 2 - B4B	2 pcs	8/5/19	8/5/19	0.00	0.20	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		



Container No: S199663



Part: RB23003267-9

Job No: 197220

Serial No/Batch: S199663

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 07/22/19

Engraving done at op 100

U/R

DAS
81
9-89

JUL 29 2019

U/R

125 QC 5	2 pcs	8/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Packaging 3-1 - Stock - B4B	2 pcs	8/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	8/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

N/R

N/R

DAS
28
9-89QC 21
SA
53

AUG 01 2019

Part Op 100 - Assemble as per drawing using LOC TITE multipurpose epoxy.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 120 - Laser engrave as per drawing.

125 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB23003267-9A	#22 Drill Bit	2 pcs (1 ea)	100-Small Fab - 1	5199054
RB23003267-9B	Block	2 pcs (1 ea)	100-Small Fab - 1	5160908

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RB23003267-9A	2	0	0
	RB23003267-9B	2	4	0

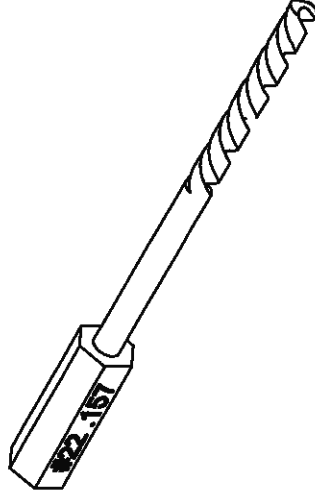
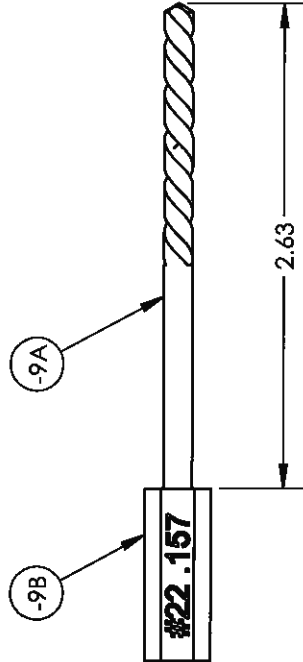
Part Specifications

Specifications could not be found.

Plex 7/3/19 8:46 AM Dart.lajeunesse.marie

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REV		REVISIONS		DESCRIPTION		DATE		INITIAL		APPROVED	
REV	ECR										



SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197720 NLS
190703

NOTE:
ASSEMBLE WITH EPOXY.



TITLE
POWER TURBINE CLEANING KIT

DWG NO.	RB23003267-9	REV	4
MAT'L	UNLESS OTHERWISE SPECIFIED		
HEAT	DIMENSIONS ARE IN INCHES		
FINISH	XXX $\pm$.005 FRACTIONS 1/16		
SPEC	XX $\pm$.01 ANGLES 1/16		
	X $\pm$.01 SURFACES = 125/		
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES	
CHECKED:	CLOUGH	2. DIMENSIONS IN PARENTHESES APPLY	
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER	
QA APPR:	LINDSAY	ASME Y14.5M-2009	
APPROVED:	GILBERT	USED ON MODEL	
SCALE	1:1	DATE	1/17/2001
		SEE NOTE 1, SHEET 1	
		SHEET 12 OF 18	

#22 DRILL BIT ASSEMBLY

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042)	
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition			
Description Work Order Deviation		Completed By							
Root Cause		Lead hand / Supervisor							
QC / QA Coordinator		Fault Category							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:		Other/Details:							